



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G26551-3G-PO

Job Sheet 185352



Part No: RBW6205G26551-3G-PO

Job Qty: 2 ea

Part Name: Main Rotor Scissor Locknut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/25/18

Job Tracking No:

Due Date: 12/17/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6205G26551-3G Rev.B IPP Rev. A 18.10.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs		12/17/18	0.00	0.00	Purchasing		DEC 17 2018
110	Packaging	2 pcs		12/17/18	0.00	0.00	Packaging2		DEC 17 2018
120	QC	2 pcs		12/17/18	0.00	0.00	QC6		38
121	Small Fab	2 pcs		12/17/18	0.00	2.00	Small Fab-5		9-89 DAS
122	QC	2 pcs		12/17/18	0.00	0.00	QC5		30
130	Packaging	2 pcs		12/17/18	0.00	0.00	Packaging3		9-89
140	QC21-FG	2 Ea		12/17/18	0.00	0.00	QC21		21 DEC 19 2018

Part Op 100 - Issue P/O: 041367 MANUFACTURE RBW6205G26551-3G AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

121 - 1-Pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G26551-3GP	Main Rotor Scissor Locknut	2 Ea (1 ea)	100-Purchasing	5137785
APP-1030-E	Case	2 Ea (1 ea)	121-Small Fab	
RBW6205G26551-3G-5	Bottom Foam use in case APP-1030-E	2 Ea (1 ea)	121-Small Fab	
RBW6205G26551-3G-7	Top Foam use in case APP-1030-E	2 Ea (1 ea)	121-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G26551-3GP	2	0	0
121-Small Fab	APP-1030-E	2	13	0
	RBW6205G26551-3G-5	2	2	0
	RBW6205G26551-3G-7	2	2	0

Part Specifications

Specifications could not be found.

Plex 10/25/18 11:35 AM dart.Lussier.Patrick



Container No: S137789



Part: RBW6205G26551-3G

Job No: 185352

Serial No/Batch: S137789

Revision: B

Inspector:

Exp Date:

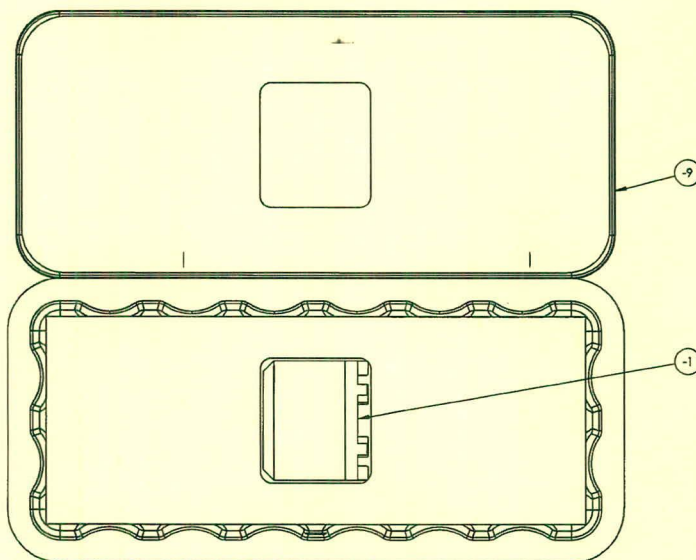
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/17/18

ITEM #	QTY	PART #	TITLE	PO
-1	1	RBW6205G26551-3G-1	M/R SCISSOR LOCKNUT	2
-8	1	RBW6205G26551-3G-8	PACKAGING ASSY	3

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
1	RELEASED FOR PRODUCTION	-	4/13/2015	C	JAG
B	TEMPLATE UPDATED, ASSY-8 PACKAGING ADDED	17-798	17.12.20	VM	ML

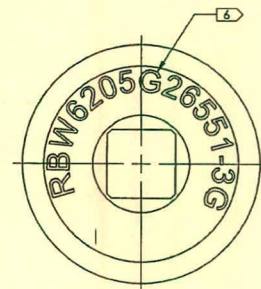
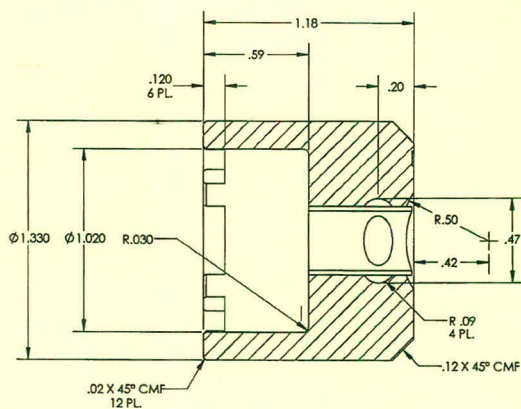


RBW6205G26551-3G MAIN ROTOR SCISSOR LOCKNUT

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A

DART AEROSPACE	
Hawthornby, Ontario, Canada	
TITLE MAIN ROTOR SCISSOR LOCKNUT	
PART NO. RBW6205G26551-3G	REV B
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES FOR ALL DIMENSIONS DIMENSIONS APPLY AFTER FINISHING	
DESIGNED BY: VM 17/12/20	TECHNICAL: JAG 1/2015
CHECKED BY: VM 12/20/2017	XX 1/21
APPROVED BY: ML 12/21/2017	XX 1/21
MFG REVIEW BY: DD 01/02/2018	SCALE: N/A
APPROVED BY: ML 01/02/2018	SHEET 1 OF 1
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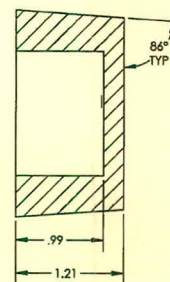
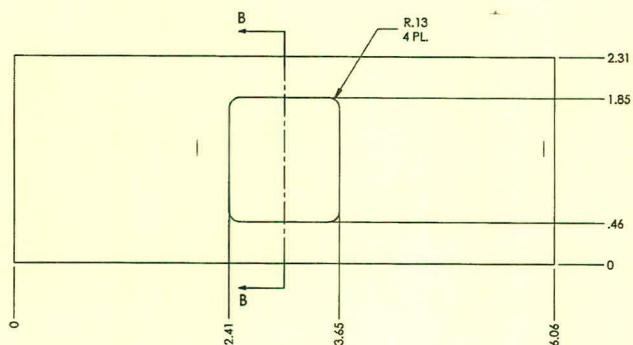
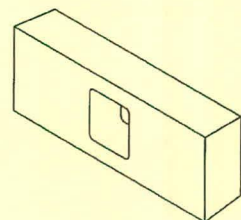
REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
B	ENGRAVE CHANGED FOR MACHINE ENGRAVE, TEMPLATE UPDATED, DIMENSION .145 CHANGED FOR .145 +/- .001, CAD PLATE YELLOW CHANGED FOR ZINC PLATE (SPEC UPDATED), MATERIAL 4140/4142 Q&T UPDATED FOR 4140/4142 (28-32 Rc)	17-798	17.12.20	VM	ML



NOTES:
1) MATERIAL: 17-4 PH-H900 SS
2) HEAT TREAT: N/A
3) FINISH: N/A
4) SPEC: N/A
5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
6) IDENTIFICATION: MACHINE ENGRAVE T/N AS SHOWN, 0.010" DEEP

		Hawthornby, Ontario, Canada	
M/R SCISSOR LOCKNUT			
RBW6205G28551-3G-1		REV B	
PART NO		REV	
TITLE		UNLESS OTHERWISE SPECIFIED DIMENSIONS AND ALL FINISHES SHALL BE IN ACCORDANCE WITH THE REQUIREMENTS APPLY AFTER TOLERANCES	
RBW6205G28551-3G-1		DETAILS AND DATE	
CHANGED BY: VM 1/12/2015		TECHNICAL: JDE 1/12/2015	
CHANGED BY: VM 1/20/2015		SIZE: J	
CHANGED BY: NM 1/21/2017		ANGLES: 90, 8, 81	
PM REVIEW BY: CM 01/02/2018		FRACTIONS: 3/16	
APPROVED BY: CM 01/04/2018		ROUNDS:	
SCALE: NTS		THICKNESS:	
CONTRIBUTE TO PART BY: DART Aerospace Ltd		SHOOTS: 2 OF 6	
THIS DOCUMENT IS PROPERTY OF DART Aerospace and shall remain the property of DART Aerospace Ltd if sent to any other person without prior written consent of DART Aerospace Ltd.			
NEW DART Aerospace Ltd			

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
B	TEMPLATE UPDATED	17-796	17.12.20	VM	ML

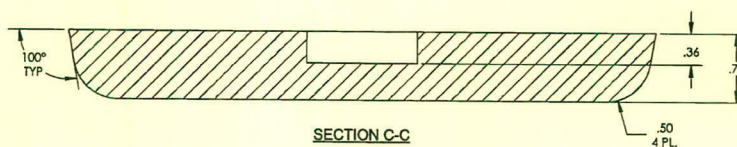
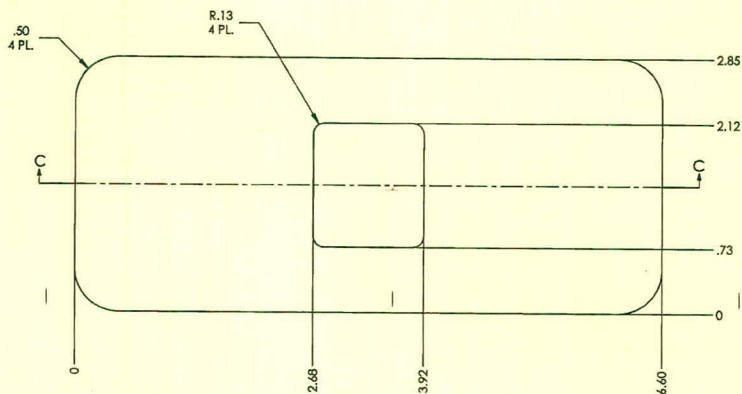


RBW6205G26551-3G-5 BOTTOM FOAM

- NOTES:**
- 1) MATERIAL: Y20 BLACK
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A

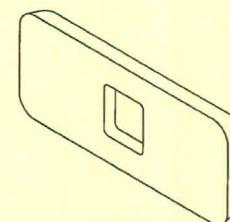
DART AEROSPACE	
Hemelburg, Ontario, Canada	
TITLE	
BOTTOM FOAM	
PART NO.	REV
RBW6205G26551-3G	B
TOOL NO.	
RBW6205G26551-3G	
DETAILS AND DATE	
DESIGNED BY: VM 17/12/20	TOLERANCES: DEC & .005
DRAWN BY: VM 12/22/2017	FRACTIONS: 1/8
CHECKED BY: ML 12/21/2017	ANGLES: 2.5°
INFO REVIEW BY: DD 01/02/2018	SURFACE: 3.2
APPROVED BY: ML 01/04/2018	ROUGHNESS: 3.2
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REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
B	TEMPLATE UPDATED	17-796	17.12.20	VM	ML



SECTION C-C

RBW6205G26551-3G-7 TOP FOAM



- NOTES:
- 1) MATERIAL: Y20 BLACK
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A

DART AEROSPACE	
Hawthornbury, Ontario, Canada	
TITLE: TOP FOAM	
PART NO. RBW6205G26551-3G-7	REV B
DIMENSIONS UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES PER ASME Y14.5-2009 DIMENSIONS APPLY AT TEMPERATURE	
DESIGNED BY: VM 17/12/20 DRAWN BY: VM 12/20/2017 CHECKED BY: ML 12/21/2017 MFG REVIEW BY: DD 01/02/2018 APPROVED BY: ML 01/04/2018	TOLERANCES: XX ± .005 XX ± .01 XX ± .1 SURFACE ROUGHNESS
SCALE: N/A SHEET 8 OF 8 COPYRIGHT © 2017 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041367
PO Date: 10/16/18
Due Date: 12/17/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Revised

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185295	RBW6005G01631-3GP			Dial Indicator Swash Plate Scissors Support REV A	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$1,150.00/pcs	\$2,300.00
Line Item Note SIOP													
2	185392	RBW1205G00231-3Gp			Main Rotor Damper Oil Filling Adapter REV 2B	Firmed	-	12/17/18	3 pcs	0 pcs	3 pcs	\$1,000.00/pcs	\$3,000.00
Line Item Note SIOP													
3	185298	RBW6405G00332-3GP			Tail Rotor Pitch Control Adjustment Tool REV 5	Firmed	-	12/17/18	1 pcs	0 pcs	1 pcs	\$1,500.00/pcs	\$1,500.00
Line Item Note SIOP													
4	185299	RBW6005G01531-3GP			Dial Indicator Main Rotor Damper Support REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$900.00/pcs	\$1,800.00
Line Item Note SIOP													
5	185300	RBW6405G00531-3GP			Tail Rotor Damper Length Adjustment Tool REV A	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$700.00/pcs	\$1,400.00
Line Item Note SIOP													
6	185301	RBW6405G02131-3GP			Tail Rotor Blade Damper Attachment Bushing Removal REV D	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$500.00/pcs	\$1,000.00
Line Item Note SIOP													
7	185302	RBW6205G05951-3GP			RBW6205G05951-3GP REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$450.00/pcs	\$900.00
Line Item Note SIOP													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	185303	RBW3205G00151-3GP			Main Landing Gear R&R Wrench REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$400.00/pcs	\$800.00
Line Item Note SIOP <i>ORDER 7393 22 Jan 2019</i>													
9	185349	RBW6205G26631-3GP			Wrench, MR Scissor Retaining Nut Removal/Install REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$280.00/pcs	\$560.00
Line Item Note SIOP													
10	185352	RBW6205G26551-3GP			Main Rotor Scissor Locknut REV B	Firmed	-	12/17/18	2 Ea	0 Ea	2 Ea	\$175.00/Ea	\$350.00
Line Item Note SIOP <i>2X DEC 17 2018</i>													
11	185353	RBW109-3101-58-2P			Hammer, Aluminum, Blade Corrosion and Voids Detection REV 3	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$150.00/pcs	\$300.00
Line Item Note SIOP													
12	185354	RBW109-3101-58-1P			Hammer, Steel, Blade Corrosion and Voids Detection REV 3	Firmed	-	12/17/18	1 pcs	0 pcs	1 pcs	\$150.00/pcs	\$150.00
Line Item Note SIOP													
13	185406	RBW6205G03451-3GP			Bolt Guide Removal & Install REV 2B	Firmed	-	12/17/18	3 Ea	0 Ea	3 Ea	\$625.00/Ea	\$1,875.00
Line Item Note SUB ASSEMBLY OF RBW6205G00331-3G <i>ORDER 7393 22 Jan 2018</i>													
14	185407	RBW6205G08451-3GP			Puller Bolt Removal REV 2B	Firmed	-	12/17/18	3 Ea	0 Ea	3 Ea	\$625.00/Ea	\$1,875.00
Line Item Note SUB ASSEMBLY OF RBW6205G00331-3G <i>3X DEC 17 2018 ORDER 7393 22 Jan 2018</i>													
15	185423	RBW6205G08031-3GP			Main Rotor Flanged Bushing Removal Tool REV 2	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$1,125.00/Ea	\$1,125.00
Line Item Note SUB ASSY FOR RBW6205G06231-3G <i>1X DEC 17 2018 ORDER 7393 22 Jan 2018</i>													
16	185424	RBW6205G08131-3GP			Main Rotor Flanged Bushing Install Tool REV 2	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$1,125.00/Ea	\$1,125.00
Line Item Note SUB ASSY FOR RBW6205G06231-3G <i>ORDER 7393 22 Jan 2018</i>													
17	185429	RBW6405G08832-3GP			Tail Rotor Bushing Install Tool As Per Dwg RBW6405G08832-3G Rev/ D	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$875.00/Ea	\$875.00
Line Item Note SUB ASSY FOR RBW6405G08632-3G <i>ORDER 7393 08 Jan 2019</i>													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
18		RBW6405G08732-3GP			Tail Rotor Bushing Removal Tool RBW6405G08732-3G Rev. E	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$875.00/Ea	\$875.00
Line Item Note SUB ASSY FOR RBW6405G08632-3G													
19	185430	RBW6205G10451-3GP			Threaded Rod	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
20	185431	RBW6205G10551-3GP			Hammer	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
21	185432	RBW6205G10351-3GP			Guide REV 1	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
22	185433	RBW6205G10251-3GP			Threaded Rod	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
23	185434	RBW6205G10151-3GP			Pusher REV 1	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
24	185435	RBW6205G10651-3GP			Stop	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
25	185461	RBW6305G26631-3G-1P			Pin REV 2	Firmed	-	12/17/18	8 Ea	0 Ea	8 Ea	\$56.25/Ea	\$450.00
Line Item Note SUB ASSY FOR RBW6305G26631-3G													
26	185462	RBW6305G26631-3G-3P			Handle REV 2	Firmed	-	12/17/18	8 Ea	0 Ea	8 Ea	\$56.25/Ea	\$450.00
Line Item Note SUB ASSY FOR RBW6305G26631-3G													
Grand Total:												\$23,959.98	

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/29/18 8:45 AM dart.Lussier.Patrick

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Shipment No: 24384
Shipment Date: 13-Dec-2018
Ship Via: Pick up at METEC
Order Number: 3096
Order Date: 10/17/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041367 ✓
Terms: Net 60 Days

----- Quantity -----									
Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision	Job Number	
11	2	2 ✓	0	0	EA	DART-RBW6205G26551-3GP Main Rotor Scissor Locknut	B	3096-11	DAS 38 9-89
15	3	3 ✓	0	0	EA	DART-RBW6205G08451-3G M/R BLADE RETENSION BOLT PULLER	2B	3096-15	
16	1	1 ✓	0	0	EA	DART-RBW6205G08031-3GP Main Rotor Flanged Bushing Removal Tool	2	3096-16	
21	1	1 ✓	0	0	EA	DART-RBW6205G10551-3GP Hammer	-	3096-21	
25	1	1 ✓	0	0	EA	DART-RBW6205G10651-3GP Stop	-	3096-25	
26	8	8 ✓	0	0	EA	DART-RBW6305G26631-3G-1P MGB Alignment Pin	2	3096-26	

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
1 ✓	DART-RBW6205G26551- 3GP ✓	Main Rotor Scissor Locknut	B	41367 ✓
3 ✓	DART-RBW6205G08451- 3G ✓	M/R BLADE RETENSION BOLT PULLER	2B	41367 ✓
1 ✓	DART-RBW6205G08031- 3GP ✓	Main Rotor Flanged Bushing Removal Tool	2	41367 ✓
1 ✓	DART-RBW6205G10551- 3GP ✓	HAMMER	2	41367 ✓
1 ✓	DART-RBW6205G10651- 3GP ✓	STOP	-	41367 ✓
8 ✓	DART-RBW6305G26631- 3G-1P ✓	MGB Alignment Pin	2	41367 ✓

DAS
38
9-89

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

